

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028486**Date Inspected:** 25-Sep-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

At the start of the shift this Quality Assurance Lead Inspector (QAI) traveled to the SAS project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) Quality Control (QC) personnel. The observations and inspections were performed as noted below:

A). This Quality Assurance Lead Inspector (QALI) assigned the QA Inspectors to the following, but not limited to the work station(s) listed, to observe the welding and the QC inspection of the following:

Joselito Lizardo-OBG E12 (Observation of excavations, repair welding, QC inspection and testing of the deck access hole insert plate identified as 12E-PP116.5-E5), E13 Drop-In Panel (Observation of welding, QC inspection and testing of the floor beam identified as E13-PP114-E2.1-PS1) and performed QA/VT & MPT verification at various areas as requested by the contractor's QC Department.

Rodney Patterson-OBG E13 Drop-In Panel (performed QA/UT verification of the deck access hole identified as 13W-PP124.5-W5 at the request of the contractor's QC Department).

Fritz Belford-OBG W12 Corner Drop-In Ass'y. (Observation of production welding, QC inspection and testing of floor the beams).

Matt Daggett-OBG W12 Corner Drop-In Ass'y. (Observation of excavations, repair welding, QC inspection and testing of floor beams identified as 13W-PP115.5-W2.1-PS1, 13W-PP116.5-W2.1-BW2 and 12W-PP117-W2.1-BW2).

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William Clifford-OBG E13 Drop-In Panel (Observation of excavation, repair welding, QC inspection and testing of the "A" deck field splice plates identified as 13E-14E-A.0 and 13E-PP121.6).

Doug Frey-OBG E12 Corner Drop-In Ass'y (Observation of excavations, repair welding, QC inspection and testing of the "A" deck field splice identified as 12E-E2.1 and the floor beam identified as 12E-PP114.5-E2.1-BW2) and OBG E12 Corner Drop-In Ass'y (Observation of the welding, QC inspection and testing of the floor beams).

Scott Croff-Continued review of welding report packages 124, 125 and 126 prior to submittal and OBG W12 (Observation of excavation, repair welding, QC inspection and testing of the deck access hole insert plates identified as 12W-PP116.5-W5).

NOTE: See QA daily Weld Inspection Reports (WIR) and NDE reports for additional information and details.

### Quality Assurance Lead Inspector (QALI) Summary

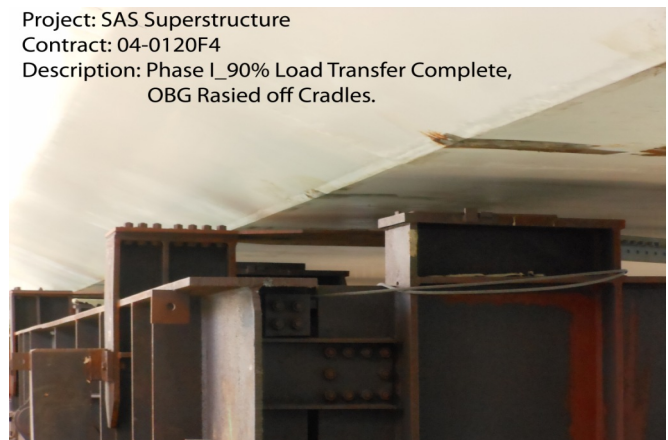
This QA Lead Inspector (QALI) observed the QA Inspector's Joselito Lizardo, Scott Croff, William Clifford, Rodney Patterson, Fritz Belford, Doug Frey and Matt Daggett monitor the work performed by the QC inspectors at random intervals and also observed the QA Inspectors verify the welding parameters, the minimum preheat and the maximum interpass temperatures for compliance with the contract specifications. The QAI's utilized a Fluke 337 clamp meter to measure the electrical welding parameters, Tempil Heat Indicators and/or a Fluke 63 IR Thermometer for verifying the preheat and interpass temperatures. At the conclusion of the shift, this QA Lead Inspector discussed and reviewed the work performed by the QAI's in regards to the various observations and the verifications of the WPS's, consumables, welding parameters, preheat and interpass temperatures. The QAI observations of the QC inspection and verification of the welding parameters performed on this date appeared to comply with the contract specifications. There were no issues noted during this shift.

This QA Lead Inspector commence the review of NDT reports, tracking of welding and developing and generating weld maps for W13 drop-in panels, E12 and W12 corner drop-in assemblies.

The digital photographs below illustrates some of the activities observed during this shift.



Project: SAS Superstructure  
Contract: 04-0120F4  
Description: Jacking Saddle 95%  
Extended.



Project: SAS Superstructure  
Contract: 04-0120F4  
Description: Phase I\_90% Load Transfer Complete,  
OBG Rased off Cradles.

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### Summary of Conversations:

There were general conversations with Quality Control Lead Inspector, Bonifacio Daquinag, Jr., at the start of the shift regarding the location of welding, inspection personnel scheduled for this shift.

There were also, other pertinent conversations with QA Supervisor, William Levell, throughout the course of this shift in regards to scheduling of QA personnel, work progress and related structural steel and weld issues. There were no issues noted during this shift.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Reyes,Danny	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell,Bill	QA Reviewer

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